# Work Order ID 57964

*April 21, 2010 9:19:59 AM*



**Item ID:** D2530 **Accept** **Setup Start**

**Revision ID:** **Stop**

**Item Name:** Handle Weldment

**Start Date:** 21/04/2010 **Start Qty:** 6.00 **Cust Item ID:**

**Required Date:** 28/04/2010 **Req'd Qty:** 6.00 **Customer:**

**Reference:**

**Approvals:** **Process Plan:** RM **Date:** 10-4-21 **Tooling:** _____ **Date:** _____ **Run Start**

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

| Draw Nbr | Revision Nbr |
|---|---|
| D2530 | Rev B |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 100 | Small Fab | 0.00 | | | | | | | |
| Small Fab | **Memo** | 0.00 | | | | | | | |
| Small Fab | 1-Cut to length as per Dwg D2536<br>2-Deburr | SAP 10-04-29 | | | | | | | |
| 110 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | δ 10/04/29 | | | | +6 | | | |
| 120 | Weld per dwg A/R S.S. rod Batch: M108160 | 0.00 | | | | | | | |
| Large Fab | | | | | | | | | |
| Large Fab | **Memo** | 0.00 | | | | | | | |
| | 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301 | | | | | R 10-5-3 | | | +6 |

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**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130<br>QC<br>Quality Control | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | 6 | | | |
| | **Memo** | 0.00 | | | | ND 10.05.04 | | | |
| 140<br>QC<br>Quality Control | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | **Memo** | 0.00 | | | | +6 | | | |
| 150<br>Powdercoat<br>Powder Coating | Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 | 0.00 | | | | | | | |
| | M1056427<br>**Memo**<br>START TIME: 7:45pm<br>OVEN TEMPERATURE: 320°F<br>FINISH TIME: 8:15pm | 0.00 ML 10/05/07 | | | | 6 | | | |

& w/o 564.

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**Start Date:** 21/04/2010 **Start Qty:** 6.00 **Cust Item ID:**

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**Reference:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 160 | QC3- Inspect Part Finish | 0.00 | | | | 6 | | | BL 10-5-7. |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | Identify as per dwg & Stock Location: 506 | 0.00 | | | | | | | 10/5/10 (6) |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | 10/05/10 |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

BL 10-5-10 (4)

# Picklist Print

*April 21, 2010 9:20:04 AM*



**Work Order ID:** 57964

**Parent Item:** D2530

**Parent Item Name:** Handle Weldment

**Comments:** IPP Rev:E Removed Purchasing 05-11-07 JLM

**Start Date:** 21/04/2010 **Required Date:** 28/04/2010

**Start Qty:** 6.00 **Required Qty:** 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| M304TR0.750W.049<br>304 RD Tube .750 x .049W | | Purchased | No | | | 100 | f | 27.8635 | 18.4074 | SAD | 10-04-29 | |

| Warehouse Location | Loc Qty | Loc Code |
|---|---|---|
| Main Warehouse | | m 114482 => 18.4074 |
| MAT017 | 27.8635 | |
| 109314 | 9.33 | |
| 110113 | 5.29 | |
| 112800 | 13.2435 | |

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D2534<br>Lock Plate | | Manufactured | No | | | 120 | Each | 6.0000 | 12.0000 | EL | 10-5-3 | |

| Warehouse Location | Loc Qty | Loc Code |
|---|---|---|
| Main Warehouse | | |
| WA | 6 | |
| 56552 | 6 | 6 |

59332 6 6

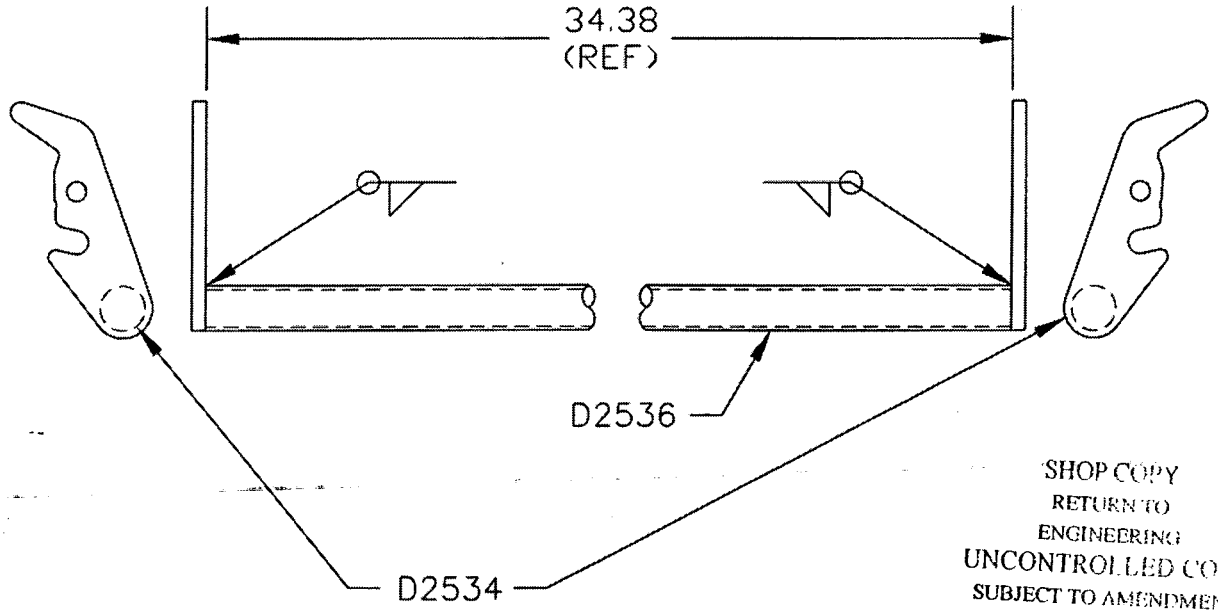
| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|---|---|---|
| B WILLIAMS | PH | VICTORIA INTERNATIONAL AIRPORT, CANADA |
| CHECKED | APPROVED | DRAWING NO. D2530 REV. B |
| | | SHEET 1 OF 1 |
| DATE 04.12.14 | | TITLE HANDLE WELDMENT SCALE |

| | | |
|---|---|---|
| A | 96.06.18 | NEW ISSUE |
| B | 04.12.14 | UPDATE NOTES AND DIMENSIONS |

RELEASED
04.12.16

## PART LIST -- D2530

| QTY | PART NUMBER | DESCRIPTION |
|---|---|---|
| X | D2530 | HANDLE WELDMENT |
| | | |
| 1 | D2536 | HANDLE |
| 2 | D2534 | LOCK PLATE |




SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 579644

BJ 10-4-21

D2530 HANDLE WELDMENT

1) WELD PER DART QSI 004
2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
3) ALL DIMENSIONS ARE IN INCHES
4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries